

Work Order ID 79508

January-26-12 3:06:52 PM

Now
79508

Page 1

Item ID: D4434-9

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bracket

Start Date: 1/26/12

Start Qty: 2.00

2

Cust Item ID:

Required Date: 1/27/12

Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: *W*

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4434

A

100

0.00

100

Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

1-Cut D4434-9 as per Dwg

Dwg Rev: *A*

Prog Rev: *A*

2-Deburr if necessary

0.00

B12-1-26

(2)

110

0.00

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

B12-1-26

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N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bracket

Start Date: 1/26/12

Start Qty: 2.00

2

Cust Item ID:

Required Date: 1/27/12

Req'd Qty: 2.00

2

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

Bend as per dwg

0.00

130

Brake NC

Memo

0.00

Brake NC

140

0.00

140

Small Fab

Memo

0.00

Small Fab

C'SINK AS PER DWG

EP 12/01/30 (2)

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Item ID: D4434-9

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bracket

Start Date: 1/26/12

Start Qty: 2.00

2

Cust Item ID:

Required Date: 1/27/12

Req'd Qty: 2.00

2

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

160

Chemical Conversion Coat per QSI005 4.1

0.00

160

HandFinish

Memo

0.00

Hand Finishing

170

QC3- Inspect Part Finish

0.00

170

QC

Memo

0.00

Quality Control

5 12/01/30

(42)

2 BR 12-1-30

2 4 12/01/30

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Item ID: D4434-9 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bracket
 Start Date: 1/26/12 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 1/27/12 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Identify as per dwg & Stock Location: GA	0.00							
210									
Packaging	Memo	0.00	88	1260130		(2)			
Packaging									
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.00							
Quality Control									

12/1/30
 1012-01-30
 (2)

Picklist Print

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Page 1

Work Order ID: 79508

Parent Item: D4434-9

Parent Item Name: Bracket

Start Date: 1/26/12

Required Date: 1/27/12

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP ReV:A 12.01.24 AS PER DWG REV.A DD VERF:EC

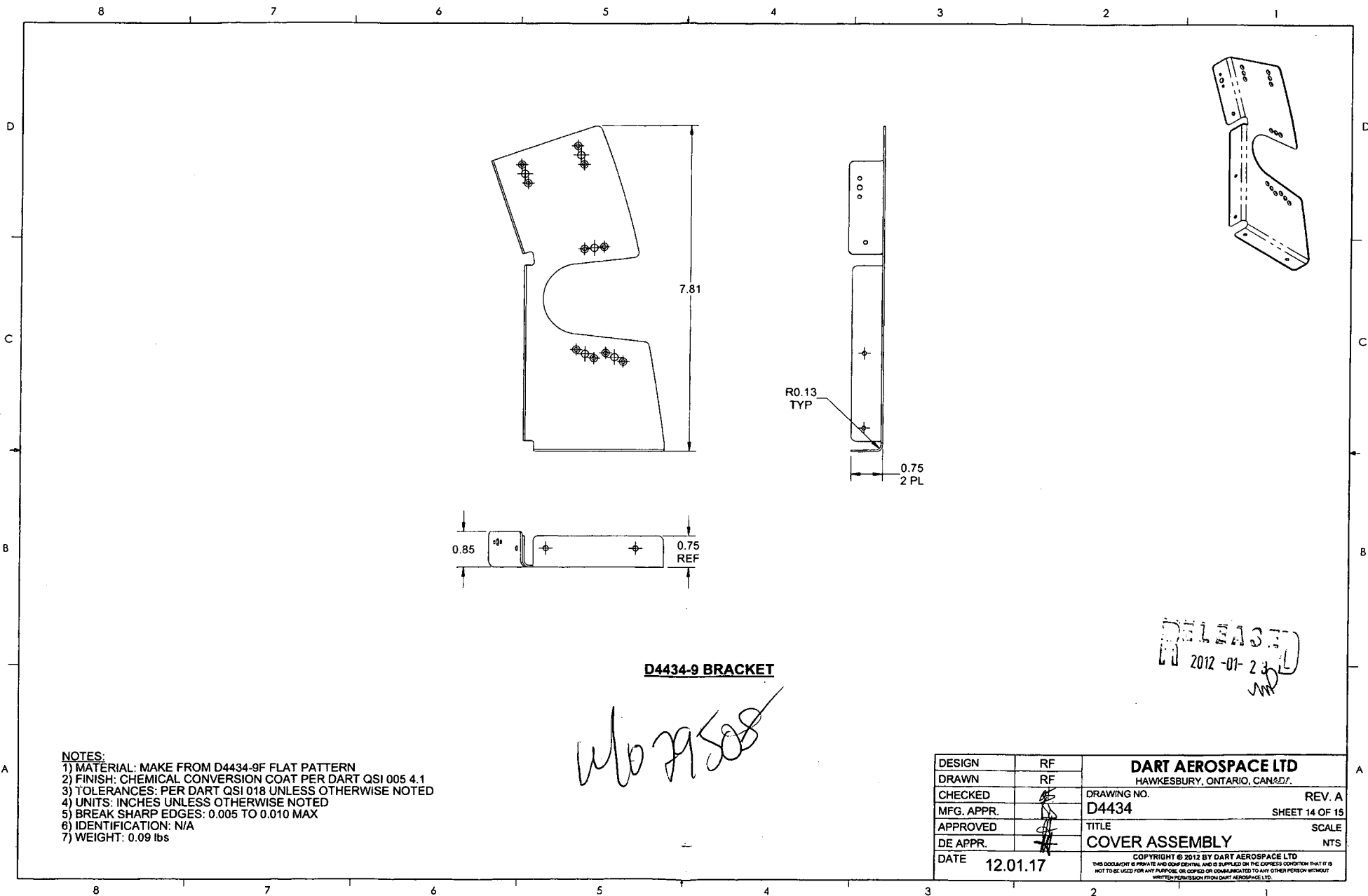
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.040 6061-T6 .040 Sheet		Purchased	No			100	sf	320.4100	0.24	0.5052632			

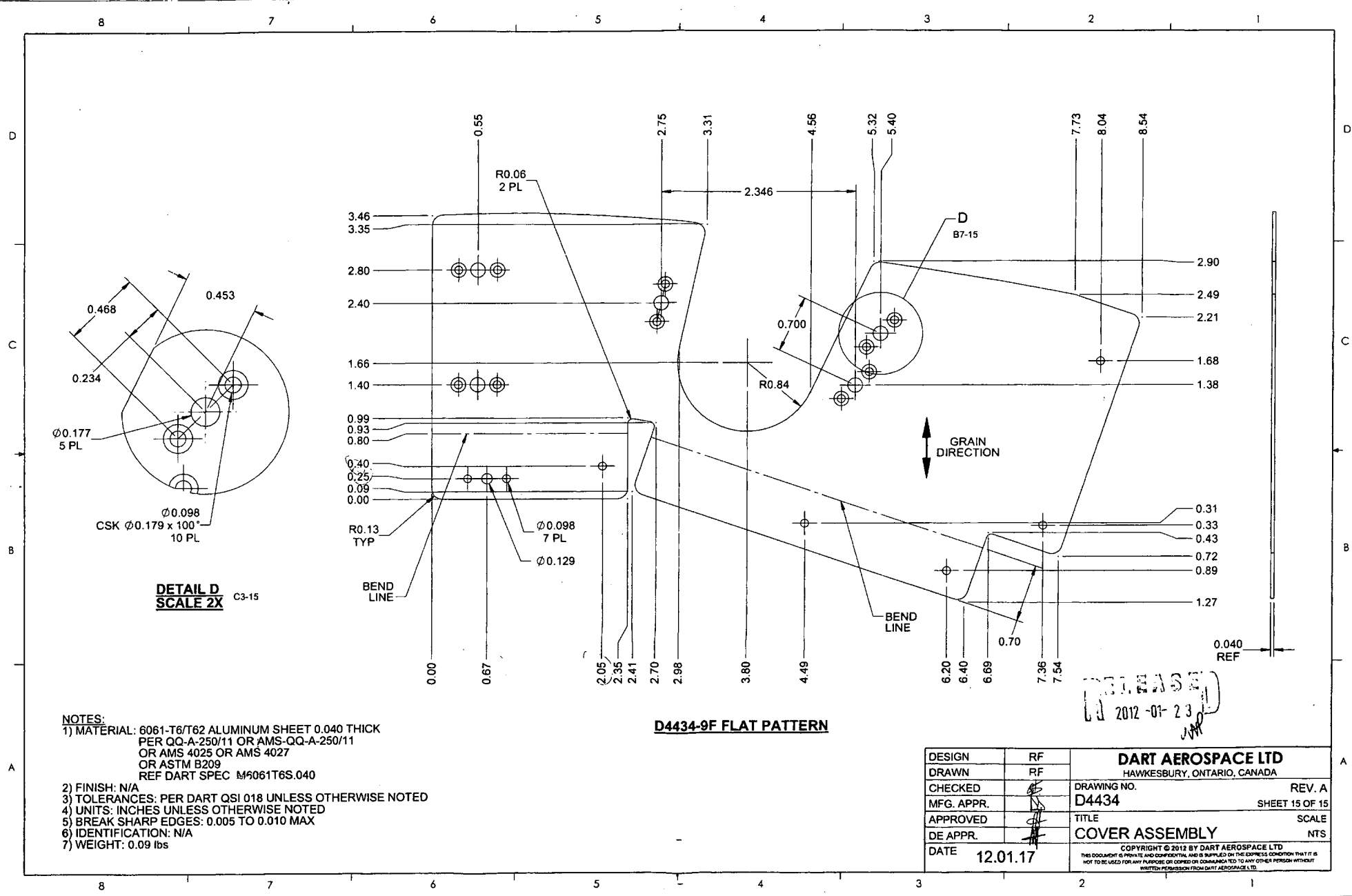
12-1-26

Location	Loc Qty	Loc Code
MAT021	320.41	
113004	2.5	
117653	40.91	
120154	95.5	
120218	181.5	

120218

2





NOTES:

- NOTES:**
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC M5061T6S.040
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.09 lbs

D4434-9F FLAT PATTERN

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. 1
MFG. APPR.	<i>[Signature]</i>	D4434	SHEET 15 OF 15
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	COVER ASSEMBLY	NTS
DATE	12.01.17	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRINTED FOR IDENTIFICATION AND IS NOT TO BE USED FOR ANY PURPOSE OR COMPARISON TO ANY OTHER PAPER PRODUCT UNLESS IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPARISON TO ANY OTHER PAPER PRODUCT UNLESS IT IS	

FIRST ARTICLE INSPECTION CHECKLIST

Description: BULKET		Inspection Dwg: D4434-9 Rev: A	
Part Number: D4434-9		Page 1 of 1	
Work Order: 79508		DART AEROSPACE LTD	

☒ First Article ☒ Prototype

Drawing	Dimension	Tolerance	Actual	Accept	Reject	Method of inspection	Comments
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Ø	1.098	+ .004 - .001	1.100	✓			
Ø	1.17	+ .005 - .001	1.177	>			

	1.25	± .030	1.251	✓			
	1.40	± .030	1.399	✓			
	2.40	± .030	2.40	✓			
	2.80	± .030	2.804	✓			
	3.46	± .030	3.461	✓			
	1.55	± .030	1.548	✓			
	1.67	± .030	1.671	✓			
	2.05	± .030	2.048	✓			
	4.49	± .030	4.488	✓			
	6.20	± .030	6.197	✓			
	7.36	± .030	7.359	✓			
	8.04	± .030	8.045	✓			
	8.54	± .030	8.530	✓			
	5.40	± .030	5.406	✓			
	2.346	± .010	2.340	✓			
	2.75	± .030	2.754	✓			
	1.33	± .030	1.336	✓			
	1.89	± .030	1.89	✓			
	1.68	± .030	1.688	✓			
	1.40	± .030	1.4038	✓			

Ø	1.129	± .005 - .001	1.129	✓			
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Measured by: B	Date: 12-1-20	Audited by: S	Date: 12/1/27	Prototype Approval:	Date:
Rev	Date	Change	Revised by	Approved	Approved
A		New Issue	KJ/JLM		